Work Order ID 126526 *126526* Page 1 Wednesday, November 12, 2014-10:38:12 A D3651-7 *N900040100* Item ID: Accept Setup Start **Revision ID:** Item Name: Bottom Flange Start Oty: **Start Date:** 11/12/2014 **Cust Item ID: Required Date:** 11/12/2014 **Reg'd Oty:** 4.00 **Customer:** Reference: Run Process Plan: MUS Date: 14-11-12 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Reject Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID **Qty** Number Stamp Code Qty **Description Run Hours** Draw Nbr **Revision Nbr** D3651 Rev B 100 0.00 FLOW WATER JET *100* 0.00 Waterjet Memo FLOW CNC Waterjet 1-Cut as per Dwg D3651 Dwg Rev: 13 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 0.00 QC Memo . Ouality Control QC8- Inspect parts - second check 0.00 120 DAS 38

0.00

Memo

9-89 -

NOV 1 3 2014

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Quality Control

| DQA: | | -J- V VIL | Date: | | | WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | | DART |
|--|---|-----------|-------------|--|------|---|------------------------------------|----------------------|---|---|---|--|---------------------------|
| QA Closed: | _ | | Date: | | | WOM ONDER WOR | | J141 O1 | MINIAITEL / N | | Vork Order up | odate only | AEROSPACE |
| Work Ord | er: | | | | | DISPOSITION | | | | /PROCESS | | | |
| Part No | | | | | | Rework Scrap Use-as-is Suspected Unapproved | | Į. | Skid-tube Machining noforming Large Fab | Crosstube Small Fab Finishing Composite | | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root | | | | | Desc | cription of work order update | | nitial | А | Action | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | hief Eng Description | | | Date | Verification | QC Inspector |
| Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved | | | | | | | | | - | | | | |
| | | | | | | | FAI | ULT CAT | regory | | | | |
| Landi | Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence | | | General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish | | Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set | | | Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/ | tolerance ct issing Vrong | Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other | | |
| | - | - | rist in Tub | | | Fit/Function | Out of Calibration Out of Sequence | | | | | | |

| Work Orde Wednesday, Nov | | | | *126 | | | | | Page 2 | | | |
|--|-----------------------|---|------------------------|------------------------------|-------------|--------|-----------------------------------|--------------|------------|---------------|------------------|----------------------------|
| Item ID: Revision ID: Item Name: | D3651-7 Bottom Flange | | | Accept | *N900 | 040 | 100 |)* | Setup | Start Stop | ı VI - | S1* |
| Start Date: Required Date: Reference: | 11/12/2014 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | Cust Item l | | | · | | | ı VI | |
| Approvals: | Process Pla | n: | Date: | Tooling: SPC (Y/N): | | ate: | | | Run | Start Stop | *N *N | R1* R2* |
| Sequence ID/ Work Center II 160 *160* Brake NC Brake NC |) | Operation Description Form as per dwg NC BRAKE Memo | | Set Up/ Run Hours 0.00 | Tool ID | Tool # | Plan Code DAS 30 9-89 | Accep Qty | t Re Qt | | Reject Number | Insp. Stamp |
| 170 *170* QC Quality Control | | QC5- Inspect part compl | eteness to step on W/C | 0.00 | · | | | 6 | <u> </u> | | | 33 9-89 NOV 1 8 2014 |
| 180 *180* Packaging | | Identify as per dwg & Sto | ock Location: WA O | 0.00 0.00 | | | | 6_ | | B | - [411 | 1-26 |

Packaging

| DQA: | | Date: | | | | | | | | | | | | |
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| QA Closed: | | Date: | | | WORK ORDER NON- | -CC | ONFO | RMANCE / UI | | Wo | ork Order up | date only | AEROSPACE | |
| | | | | | DISPOSITION | | | | | | PARTMENT | *************************************** | <u>, </u> | |
| Work Orde | r: | | | | DISPOSITION | | | | AGAINST | <u> </u> | PAKTIVIENT <i>)</i> | PROCESS _ | | |
| Part N | O | | | | Rework Scrap | | Machining Small Fa | | Crosstube Small Fab | | Water Jet Prod. Eng. Coor. | | Engineering Quality | |
| NCR N | 0 | | | | Use-as-is Thermoforming Suspected Unapproved Large Fab C | | Finishing Composite | | Rec/Stor | e/Packaging Supplier | Other | | | |
| Root | | | | Desci | ription of work order update | | Initial Action | | ion | | Sign & | | | |
| Cause | Date | Step | Qty | } | or non-conformance | Ch | ief Eng | Descr | ription | | Date Verification | | QC Inspector | |
| Design | | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | |
| quip/Tooling | | | | | | • | | | | | | | | |
| landling/Pre | _ | | | | | | | | | | | | | |
| Material | _ | | | | | | | | | | | | | |
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| Offset/Setup | | | | | | | | | | | | | | |
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| <u> </u> | Bending | | | <u> </u> | Bend | | 1 | rogram | | | Outside Dim | ├ | Pressure/Forced | |
| - | Centre No | ot Concei | ntric | <u> </u> | BOM/Route | | Grain | | | | Over/Under | ⊢ | Set-up | |
| | Cracks | | | <u> </u> | Broken/Damage/Defect | _ | Hardwa | | | | Part Incorred | · · · - | Temperature/Cure | |
| - | Crimp/Kir | nk/Ripple | :/Wave | - | Burrs | | 1 | ion Incomplete/Ur | | | Part Lost/Mi | ssing | Weld | |
| - | Cuffs | | | <u> </u> | Contamination | $\overline{}$ | ł | ions Incomplete/U | Jnclear | | Part Moved | L | Wrong Stock Pulled | |
| - | Crushing | | | Countersink | | 1 - | ned/off center | | | Positioned V | _ | - | | |
| - | Heat Trea | | | <u> </u> | Cut Too Short | | Mislabe | | | | Power Loss/ | Surge | Other | |
| - | Inspection | | Tube | <u> </u> | Drawing | <u> </u> | Misread | | | | | | | |
| - | Marks/Ch | | | <u> </u> | Drill Holes | | Off-set | | | | | | | |
| - | Turning S | | | <u> </u> | Finish | _ | 1 | Calibration | | | | | | |
| | Wave/Tw | ist in Tul | oe | | Fit/Function | Out of Sequence | | | | | | | | |

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| Work Orde Wednesday, Nov | | | | *126 | | | Pa | nge 3 | | |
|---|--------------------------|------------------------------------|--------------------|----------------------|----------------------------|--------------------|-------|---------------|-----------------------------|---|
| Item ID: Revision ID: Item Name: | D3651-7 Bottom Flange | ÷ | | Accept | *N900040 | 1100* | Setup | Start Stop | *NS1 | |
| Start Date: Required Date: Reference: | 11/12/2014 11/12/2014 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | Cust Item ID: Customer: | | | | | , |
| Approvals: | Process Pla | n: | Date: | Tooling: | Date: | | Run | Start Stop | *NR1 *NR2 | |
| Sequence ID/ Work Center II |) | Operation Description | Work Order Palence | Set Up/ Run Hours | Tool ID Tool # | Plan Ac Code Qt | - | • | Reject Insp. Number Stam | |

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Quality Control

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| QA: | · | Date: | | | | | | | | | | | | |
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| QA Closed: | | Date: | | | WORK ORDER NON | -CC | ONFO | RMANCE / UI | | Vork Order up | udata only | AEROSPACE | | |
| an ciosea. | | Date. | | | | | | | · | voik Order up | date only | | | |
| Work Orde | er: | | | | DISPOSITION | | | | AGAINST D | EPARTMENT | PROCESS | | | |
| | | | | | Rework | | | Skid-tube | Crosstube | | Water Jet | Engineering | | |
| Part N | lo. | | | | Scrap | | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality | | |
| | - | | | | Use-as-is | | | noforming | Finishing | - | re/Packaging | Other | | |
| NCR N | lo. | | | | Suspected Unapproved | 1 1 | | Large Fab | Composite | | Supplier | | | |
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| Root | | | | Desci | ription of work order update | ı | Initial | Act | ion | Sign & | | · | | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | nief Eng | Descr | iption | Date | Verification | QC Inspector | | |
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| Landir | ng Gear | | | | General | | _ | | _ | | _ | _ | | |
| | Bending | | | | Bend | | Folio/P | rogram | L | Outside Dim | ensions | Pressure/Forced | | |
| ļ | Centre 1 | Not Conce | ntric | | BOM/Route | L | Grain | | L | Over/Under | tolerance | Set-up | | |
| į | Cracks | | | | Broken/Damage/Defect | | Hardwa | re | | Part Incorred | it L | Temperature/Cure | | |
| | Crimp/K | ink/Ripple | e/Wave | | Burrs | | Inspecti | ion Incomplete/Ur | nqualified | Part Lost/Mi | ssing | Weld | | |
| | Cuffs | | | | Contamination | | Instruct | ions Incomplete/U | Jnclear | Part Moved | | Wrong Stock Pulled | | |
| | \vdash | | Countersink | | Misalig | ned/off center | | Positioned V | Vrong | | | | | |
| | Heat Tre | eat | | | Cut Too Short | | Mislabe | eled | | Power Loss/ | Surge | Other | | |
| [| Inspecti | on Strip in | Tube | | Drawing | | Misread | Ė | | | | - | | |
| [| Marks/0 | Chatter | | | Drill Holes | | Off-set | | | | | | | |
| | Turning | Sequence | | | Finish | | Out of 0 | Calibration | | | | | | |
| | Wave/T | wist in Tul | oe | | Fit/Function | Out of Sequence | | | | | | | | |

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Picklist Print

Wednesday, November 12, 2014 10:38:17 AM

Work Order ID: 126526

126526

Parent Item:

D3651-7

D3651-7

Parent Item Name: Bottom Flange

Start Date: 11/12/2014

Required Date: 11/12/2014

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA 10.11.04 as per revB DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S26GA | | Purchased | No | | | 100 | sf | 260.2272 | 0.3 | 2 | | | / |
| *M304S26 | SGA* | | | | | | | | ** | | 0 | - 14/11/ | /12_ |

| Location | Loc Qty | Loc Code | |
|------------------------|----------|----------|-------|
| MAT020 | 260.2272 | | |
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| 123135 | 54.689 | | |
| $(m130\overline{6}50)$ | 179.5382 | | 2.125 |

| DQA: | | | Date: | | | WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | | | | |
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| QA Closed: | | | Date: | | | WORK ORDER NON | -CC | ONFOR | RMANCE / U | | ork Order up | date only | AEROSPACE | | |
| Work Orde | er: | | | | , | DISPOSITION | | | | AGAINST D | EPARTMENT | PROCESS | | | |
| Part N | - No | | | | | Rework Scrap | | Skid-tube Crosstube Machining Small Fab Thermoforming Finishing | | | _ | Water Jet d. Eng. Coor. | Engineering Quality | | |
| NCR 1 | NCR No. | | | | | Use-as-is Suspected Unapproved | Large Fab Composite | | | Finishing Composite | Rec/Stor | e/Packaging Supplier | Other | | |
| Root | | | | | Desci | ription of work order update | ١ | nitial | Ac | tion | Sign & | | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Desc | ription | Date | Verification | QC Inspector | | |
| Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved | | | | | | | | | | | | | | | |
| | | | | | | | FAI | JLT CAT | EGORY | | | | | | |
| Landi | | | 9 | | | General | | - ,, , ₀ | | | 7 | . F | | | |
| , | - | Bending | | at. | | Bend BOM/Bouts | | Folio/P | rogram | <u> </u> | Outside Dim | + | Pressure/Forced | | |
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| | - | Crimp/Kink/Ripple/Wave | | | Burrs Contamination | | 1 | on Incomplete/U ions Incomplete/ | | Part Moved | F | | | | |
| | Crushing | | | | - | Countersink | - | ł | ned/off center | <u> </u> | Positioned V | | Wrong Stock Pulled | | |
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| ļ | \vdash | neat frea Inspection | | Tubo | - | Drawing | | Misread | | | Trower ross/: | ouige [| Other | | |
| ! | - | | | iube | | Drill Holes | _ | i | | | | | | | |
| | | | | | | Finish | - | Off-set | | | | | | | |
| | Turning Sequence Wave/Twist in Tube | | | | | | Out of Calibration Out of Sequence | | | | | | | | |

| DART AEROSPACE LTD | Work Order: | 126526 |
|------------------------------|--------------|-------------|
| Description: Bottom Flange | Part Number: | D3651-7 |
| Inspection Dwg: D3651 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
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| Ø0.098 | +0.004/-0.001 | ~10l | ✓ | | V=DL-02 | |
| Ø0.129 | +0.005/-0.001 | . /31 | _ | | | |
| 0.26 | +/-0.030 | . 26 | ~ | | | |
| 0.500 | +/-0.010 | ، ځرن | / | | | |
| 0.19 | +/-0.030 | .19 | / | | | |
| 0.450 | +/-0.010 | ,450 | _ | | | |
| 2.10 | +/-0.030 | 2-14 | 1 | | | |
| 2.31 | +/-0.030 | 2.31 | _ | | | |
| 6.94 | +/-0.030 | 6.94 | 1 | | | |
| 0.23 | +/-0.030 | - 23 | _ | | | |
| 3.09 | +/-0.030 | 3.09 | / | | | |
| 0.29 | +/-0.030 | - 27 | 1 | | | |
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Measured by: Date: NOV 1 3 2014

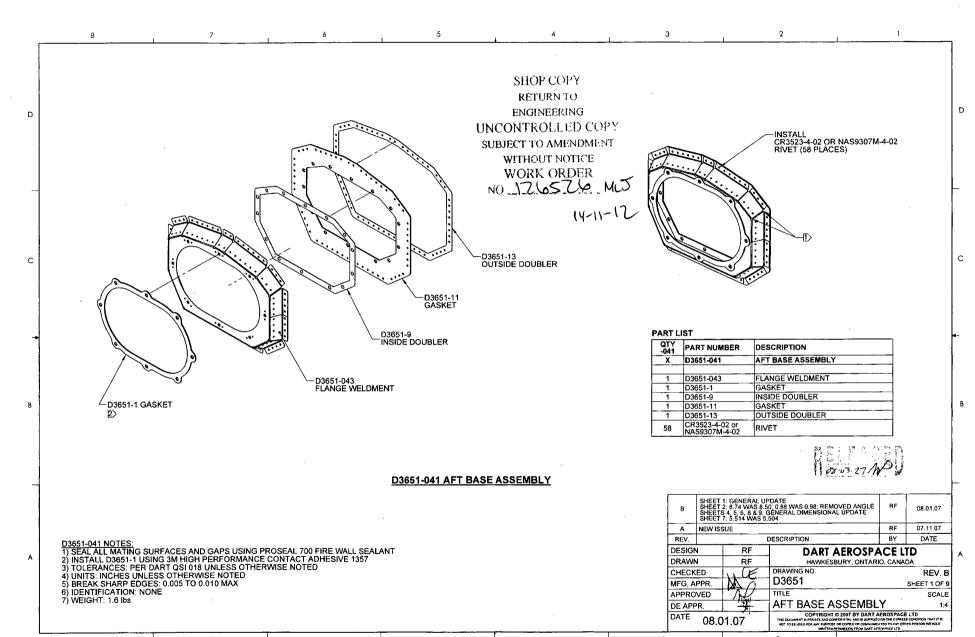
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Date: 14/4/4/12 9-89

Date: NOV 1 3 2014

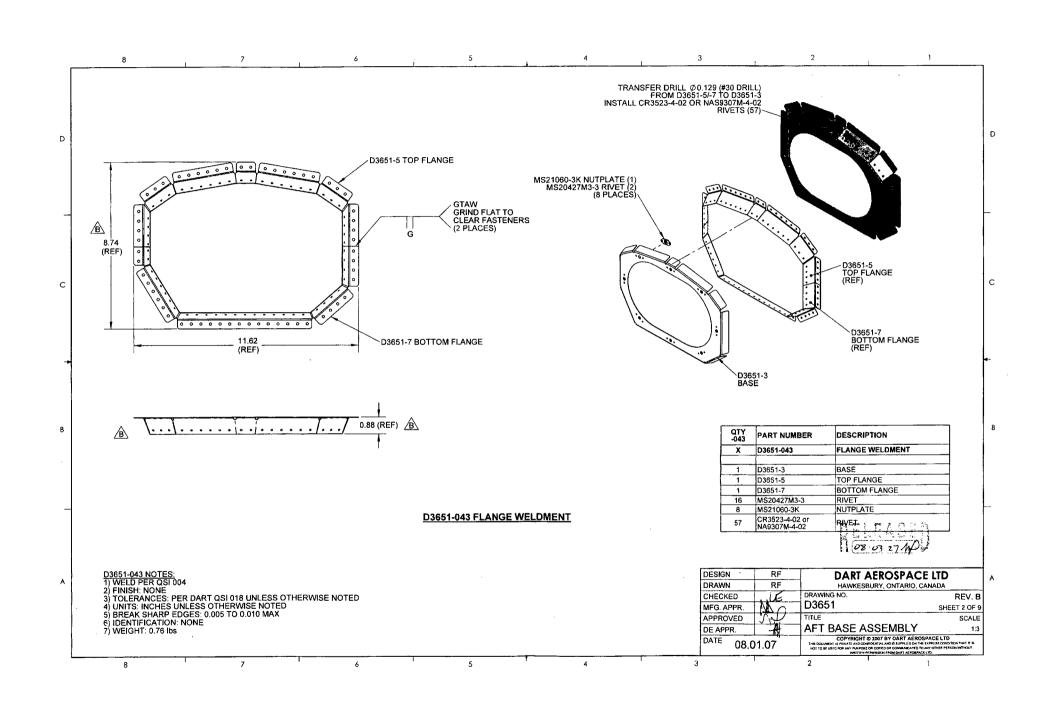
| Rev | Date | Change | | Revised by | Approved |
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| Α | 08.04.17 | New Issue | P/O D3651-043 | KJ/DD 🚓 | |
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| DQA: | | | Date: | | | | | | | | | | A DT |
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| | | | | | | WORK ORDER NON- | -CC | ONFO | RMANCE / U | PDATE | | | AEROSPACE |
| QA Closed: | | | Date: | | | | | | | V | Vork Order u | pdate only | |
| Work Orde | | | | | | DISPOSITION | | | | , | | | |
| Work Ora | - | | | | | Rework | | | Skid-tube Crosstube Water Jet | | | | Engineering |
| Part N | do | | | | | Scrap | | | Machining | Small Fab | Dro | od. Eng. Coor. | Quality |
| raiti | - | | | | | Use-as-is | | | noforming | Finishing | _ | re/Packaging | Other |
| NCR N | No. | | | | i | Suspected Unapproved | | 1110111 | Large Fab | Composite | 1 1100,310 | Supplier | |
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| Root | | | | | Desci | ription of work order update | I | nitial | Act | ion | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descr | iption | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | i | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | | | | | | : | | | | | | | |
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| Training | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | |
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| Landi | ng G | ear | | | | General | | _ | | | | | _ |
| | [| Bending | | | | Bend | | Folio/P | rogram | | Outside Din | nensions | Pressure/Forced |
| | (| Centre No | t Concer | ntric | | BOM/Route | | Grain | | <u> </u> | Over/Unde | r tolerance | Set-up |
| | (| Cracks | | | | Broken/Damage/Defect | | Hardwa | re | [| Part Incorre | ect | Temperature/Cure |
| | Crimp/Kink/Ripple/Wave | | | | Burrs | | Inspecti | on Incomplete/Un | nqualified | Part Lost/N | lissing | Weld | |
| | Cuffs | | | | Contamination | | Instruct | ions Incomplete/L | Jnclear | Part Moved | | Wrong Stock Pulled | |
| | Crushing | | | Countersink | | Misalig | ned/off center | Γ | Positioned ' | Wrong | | | |
| Heat Treat Cut To | | | Cut Too Short | | Mislabe | led | . [| Power Loss, | /Surge | Other _ | | | |
| | | | | Drawing | | Misread | 1 | | | | | | |
| | _]' | Marks/Ch | atter | | | Drill Holes | | Off-set | | | | | |
| | | Turning Se | equence | | | Finish | | Out of 0 | Calibration | | | | |
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| DQA: | Date: | | | | | | | | | | | | DART |
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| QA Closed: | | | Date: | | | | _ | | | V | ork Order up | date only | 1 |
| Work Ord | er: | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | /PROCESS | ! |
| | • | | | | | Rework | | | Skid-tube | Crosstube | Water Jet | | Engineering |
| Part I | ۷o. | | | | | Scrap | | | Machining | Small Fab | Prod. Eng. Coor. | | Quality |
| | | | | | | Use-as-is | | Therr | noforming | Finishing | Rec/Stor | re/Packaging | Other |
| NCR I | ۷o. <u>.</u> | | | | | Suspected Unapproved | | | Large Fab | Composite | | Supplier | |
| Root | | | | | Desci | ription of work order update | | Initial | Ac | ction | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | nief Eng | Desc | cription | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | |
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| Supplier | | | | | | | l | | | | | | |
| Training | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | |
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| Landi | ng G | iear | | | | General | | _ | | | _ | | _ |
| | Ш | Bending | | | | Bend | | Folio/F | rogram | | Outside Dim | ensions | Pressure/Forced |
| | Ш | Centre No | t Concer | ntric | | BOM/Route | L | Grain | | | Over/Under | tolerance | Set-up |
| | Ш | Cracks | | | | Broken/Damage/Defect | | Hardwa | ire | | Part Incorred | ct | Temperature/Cure |
| | Crimp/Kink/Ripple/Wave | | | | Burrs | L | Inspect | ion Incomplete/U | Jnqualified | Part Lost/Mi | ssing | Weld | |
| | Cuffs | | | | Contamination | | Instruct | ions Incomplete/ | /Unclear | Part Moved | | Wrong Stock Pulled | |
| | Crushing | | | Countersink | | Misalig | ned/off center | | Positioned V | Vrong | _ | | |
| Heat Treat | | | Cut Too Short | | Mislabe | eled | | Power Loss/ | Surge | Other | | | |
| | _ | Inspection | • | Tube | | Drawing | | Misread | d | | | | |
| | | Marks/Ch | atter | | | Drill Holes | | Off-set | | | | | |
| | | Turning Se | equence | | | Finish | | Out of 0 | Calibration | | | | |
| | Wave/Twist in Tube | | | | Fit/Function | | Out of Sequence | | | | | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

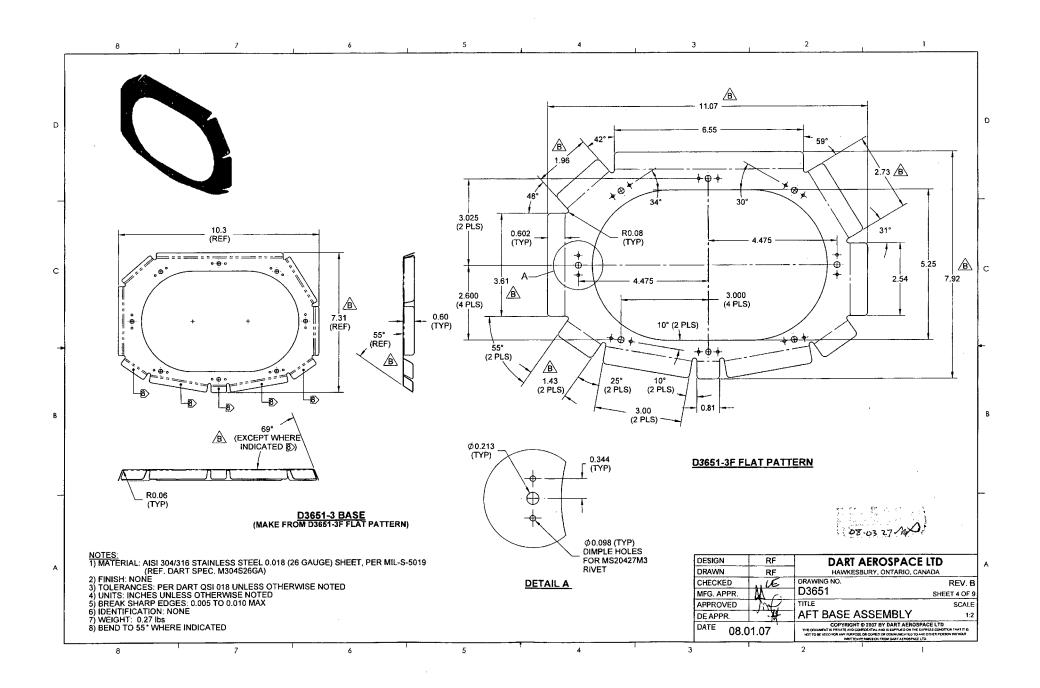
D 0.40 (TYP) Ø0.257 (TYP) R0.45 (TYP) R0.25 (TYP) С 6.69 2.60 3.03 9.59 **D3651-1 GASKET**

NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) PART IS SYMMETRIC ABOUT Q
8) WEIGHT: 0.09 lbs

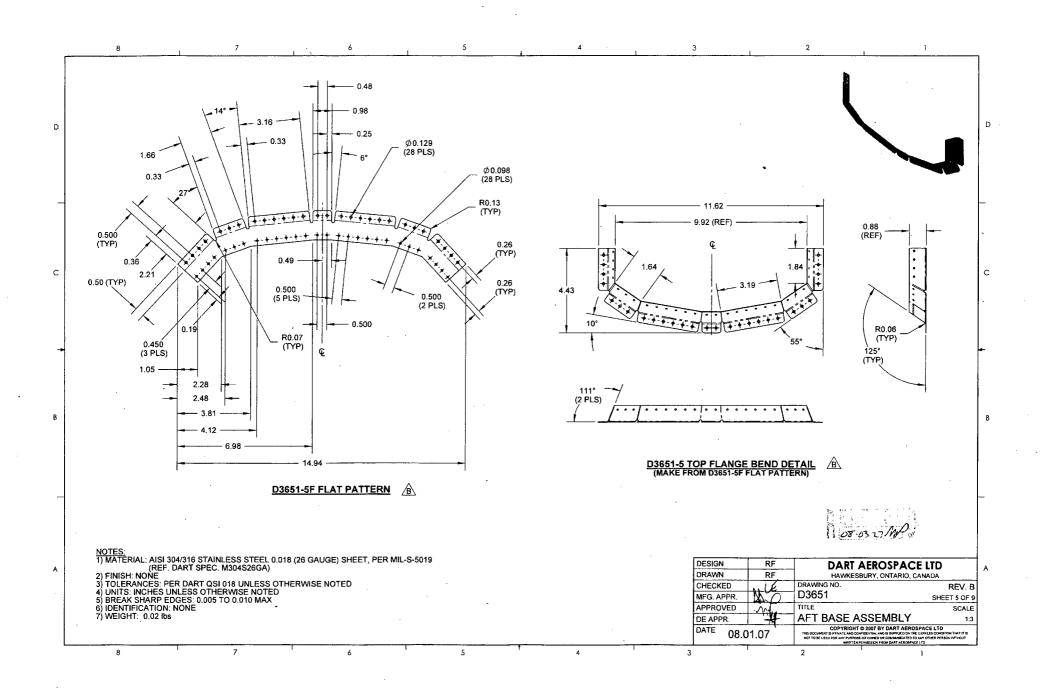
| DESIGN | RF | DART AEROSPACE LTD | | | | | | |
|------------|-------|--|--------------|--|--|--|--|--|
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | | | | | | |
| CHECKED | n.ie | DRAWING NO. | REV. B | | | | | |
| MFG. APPR. | M O | D3651 | SHEET 3 OF 9 | | | | | |
| APPROVED | 7.4 | TITLE | SCALE | | | | | |
| DE APPR. | # | AFT BASE ASSEMBLY | 1:2 | | | | | |
| DATE 08.0 | 01.07 | COPYRIGHT © 2007 BY DARY AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPONITY, AND IS RUPHIZED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES ON COMPONITY FOR ON THE PERSON WITHOUT WRITTEN PRIMEISON FORD DARY AEROSPACE LTD. | | | | | | |

| DQA: Date: | | | | | WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | | | |
|--|---|------|-------|-----|-------------------------------------|--|----|--|---|---|---------------|---------------------------|--------------|
| QA Closed: | | | Date: | | | WORK ORDER NOW | | JINFOI | NIVIAINCE / C | | Work Order up | odate only | AEROSPACE |
| Work Orde | er: | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
| Part No | | | | | | Rework Scrap Use-as-is Suspected Unapproved | | Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite | | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | | Engineering Quality Other | |
| Root | | | | | Desci | ription of work order update | | nitial | Ad | ction | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Desc | cription | Date | Verification | QC Inspector |
| Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved | | | | | | | | | | | | | |
| | | | | | | | FA | ULT CAT | TEGORY | | | | |
| Landi | Landing Gear Bending Centre Not Concentric Cracks Broken/Damage/Defect Burrs Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes | | | | | Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Misread Off-set | | | Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/ | Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other | | | |
| | Turning Sequence Wave/Twist in Tube | | | | - | Finish Fit/Function | | Out of Calibration Out of Sequence | | | | | |

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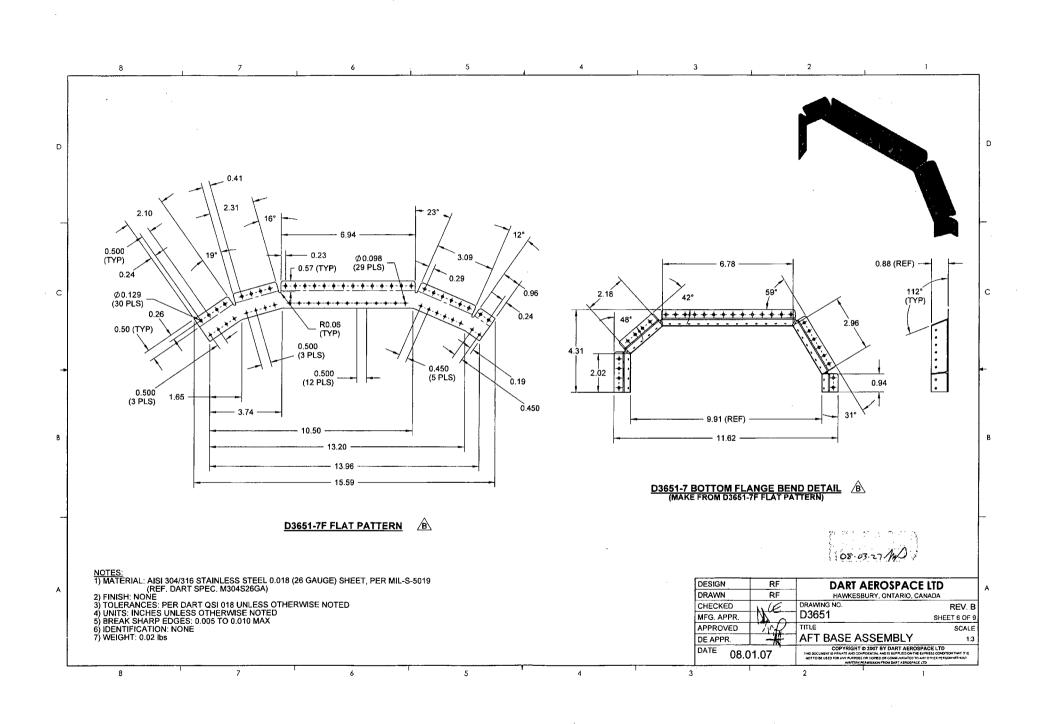


| DQA: | A: Date: | | | | | WORK ORDER NON | DART | | | | | | |
|--|---|------|-------|-----------------------------------|-------------|---|---|--|---|---|---|---------------------------|--------------|
| QA Closed: | | | Date: | | | | | | | | ork Order up | date only | AEROSPACE |
| Work Orde | er: | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
| Part No. NCR No. | | | | | | Rework Scrap Use-as-is Suspected Unapproved | Machining Small Fa Thermoforming Finishin | | Crosstube Small Fab Finishing Composite | Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier | | Engineering Quality Other | |
| Root | | | | | Desc | ription of work order update | | Initial | Act | ion | Sign & | | |
| Cause | | Date | Step | . Qty | | or non-conformance | Ch | ief Eng | Descr | ription | Date | Verification | QC Inspector |
| Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved | | | | | | | | | <u>-</u> | | | | |
| | | | | | | | FA | ULT CA1 | regory | | | | |
| Landir | Cracks Crimp/Kink/Ripple/Wave Burrs Cuffs Crushing Heat Treat Inspection Strip in Tube Drawin | | | BOM/Route Broken/Damage/Defect | | Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread | | | Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/ | tolerance ct ssing Vrong | Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other | | |
| | Marks/Chatter Turning Sequence Wave/Twist in Tube | | | e | | Finish Fit/Function | | Off-set Out of Calibration Out of Sequence | | | | | |

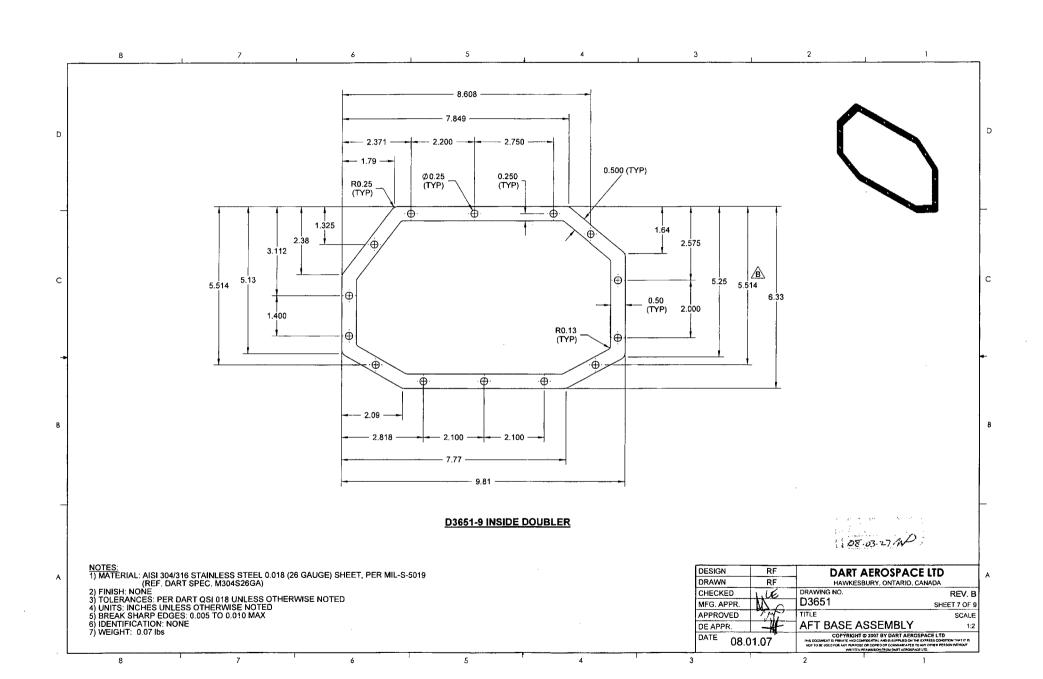


| DQA: | Date: | | | | | | | PT | | | | | | |
|---------------|------------------------|----------------------|-----------|---------------|---------------|------------------------------|---------------|------------------------------------|-------------|----------------------------|---------------------------------------|---------------|--------------------|---------|
| | | | | | | WORK ORDER NON | -CC | ONFO | RMANCE / I | | | _ | A E R C | SPACE |
| QA Closed: | | · | Date: | | | | | | | | ork Order up | date only | | |
| Work Orde | er: | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
| | | | | | | Rework | | Skid-tube Crosstube | | Crosstube | Water Jet | | Engineeri | ing |
| Part N | ١o. | | | | | Scrap | | 1 | Machining | Small Fab | Pro | d. Eng. Coor. | Qual | ity |
| | | | | | | Use-as-is | | Thern | noforming | Finishing | Rec/Stor | e/Packaging | Oth | ner |
| · NCR N | VO. | | | | | Suspected Unapproved |] | | Large Fab | Composite | _ | Supplier | | |
| Root | | | | | Desci | ription of work order update | ı | nitial | А | Action | Sign & | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Des | scription | Date | Verification | QC Insp | ector |
| Design | | | 1 | | | | | | | | | | | |
| Doc/Data | | | | | | , | | | | | | | 1 | |
| Equip/Tooling | | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | |
| Supplier | - | | | | | | | | | | | | | |
| Training _ | \dashv | | | | | | | | | | | | | |
| Transport | _ | | | | | | | | | | | | | |
| Unapproved | | | | | | | <u></u> | | FEGORY | | | | | |
| المسطان | | | | | | ····· | FA | ULI CAI | TEGORY | | | | | |
| Landii | | | | | | General | |] !:-/p | | r | 70 | : Г | | |
| | - | Bending Centre No | t Canaan | . tri n | | Bend BOM/Route | - | Grain | rogram | - | Outside Dim | F | Pressure/Fo | rcea |
| | $\neg \neg$ | Cracks | or concer | ILTIC | | Broken/Damage/Defect | - | Hardwa | | - | Over/Under Part Incorred | F | Set-up | a /Cura |
| | — | | k/Dinnla | Mayo | | Burrs | | ł | | Ungualified | ⊣ | F | Temperatur Weld | e/Cure |
| | Crimp/Kink/Ripple/Wave | | | - | Contamination | \vdash | | ion Incomplete/ ions Incomplete | · — | Part Lost/Mi Part Moved | · · · · · · · · · · · · · · · · · · · | | k Bullad | |
| | Crushing | | | - | Countersink | - | 1 | ned/off center | — | Positioned V | _ | Wrong Stock | rulleu | |
| | | | | Cut Too Short | - | Mislabe | | · | Power Loss/ | Ŭ r | Other | | | |
| | | | | Drawing | | Misread | | L | ار درون ال | | Totalet | | | |
| | \neg | Marks/Ch | | | | Drill Holes | \vdash | Off-set | - | | | | | |
| | _ | Turning Se | | | | Finish | $\overline{}$ | ł | Calibration | | | | | |
| | - | Wave/Tw | • | e | | Fit/Function | \vdash | 1 | Sequence | | | | | |

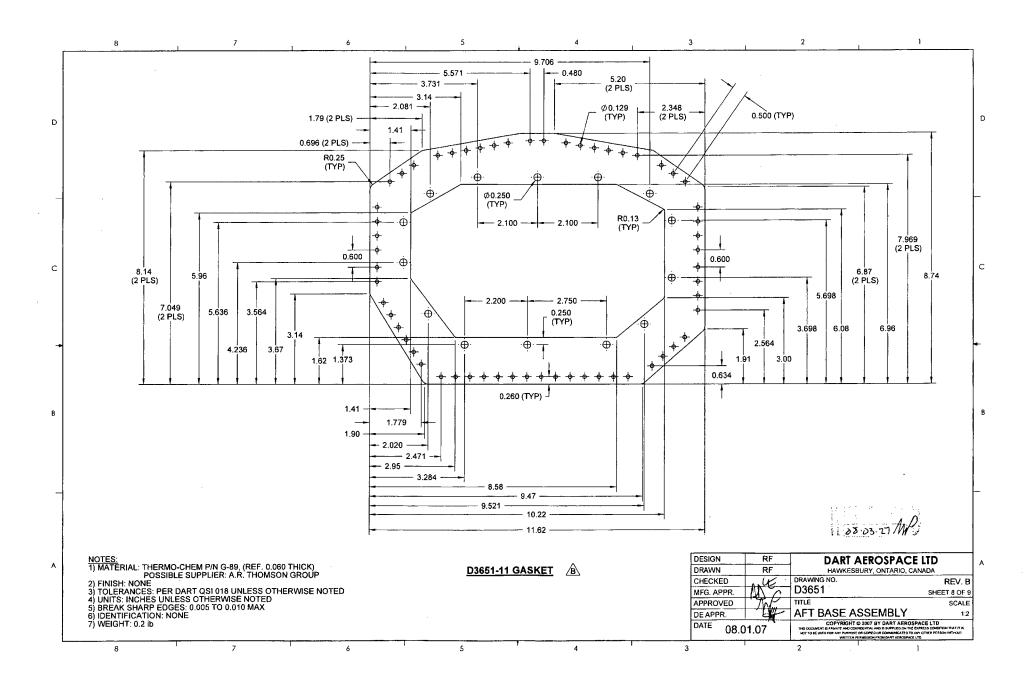
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